

Work Order ID 61795

Friday, September 03, 2010 1:40:46 PM

Page 1

Item ID: D3936-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Mapbox Assembly

Start Date: 9/3/2010 Start Qty: 4.00

Required Date: 9/14/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *H*Date: *10.9.03*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3936

A

100

0.00

Small Fab

Memo

0.00

Small Fab

1- Transfer drill holes and c'sink as per dwg (D3936-1/-3/-5)

2- Deburr

110

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

114

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

ES 10/10/14 *(4)* *(370)**See 10/14**(4)**BR 10 10 14.**(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3936-04 PAR #: W/A Fault Category: Sm. Fab NCR: Yes No DQA: 10 Date: 10.10.26
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: 10/10/26

NCR: 61795		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.10.13	100	D3936-1 was not alodined before riveting gus R.C. 100.	<i>[Signature]</i> 09/24/12	<i>[Signature]</i> De oxide with soda blende and apply Alodine with a brush. Ensure Decadizer is rinsed	<i>[Signature]</i> 10/10/13	<i>[Signature]</i> 10/10/14	<i>[Signature]</i> 09/24/12	<i>[Signature]</i> 10.10.13

NOTE: Date & initial all entries

Work Order ID 61795

Friday, September 03, 2010 1:40:46 PM



Page 2

Item ID: D3936-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Mapbox Assembly

Start Date: 9/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

115

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SB 10/10/18 (4)

116

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg (D3936-1/-3/-5)

SB 10/10/18 (4) PRO

117

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 10/10/17 (4)

W/O: 61795		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.10.13	116	MS 20426 AD3-5 IS TOO LOW. CHANGE TO MS 20426A3-4.				10.10.12 ds1042	

Part No: D3936-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61795

Friday, September 03, 2010 1:40:46 PM



Page 3

Item ID: D3936-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Mapbox Assembly

Start Date: 9/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M 112588

Memo

START TIME: 9:15
OVEN TEMPERATURE: 320°
FINISH TIME: 9:45

0.00

0.00

10-10-19



130



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

10-10-19

4 0

140



Small Fab

Small Fab

Memo

INSTALL RUBBER CUSHION AND PLACARD AS PER DWG

0.00

0.00

Ep 10/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61795

Friday, September 03, 2010 1:40:46 PM

Page 4

Item ID: D3936-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Mapbox Assembly

Start Date: 9/3/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10/10/25

(4)

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PPP
63790

10/10/25 (4)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/25
MF
10-10-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 03, 2010 1:40:52 PM

Page 1
2

Work Order ID: 61795



Parent Item: D3936-041



Parent Item Name: Mapbox Assembly

Start Date: 9/3/2010

Required Date: 9/14/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3936-1 		Manufactured	No			100	Each	0.0000	1	1			
Sides						B61796							
D3936-3 		Manufactured	No			100	Each	2.0000	1	1			
Bottom													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST185		2							
				52174		1							
				52383		1							
D3936-5 		Manufactured	No			100	Each	2.0000	1	1			
Divider													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST232		2							
				53935		2							
D3938-3 		Manufactured	No			140	Each	7.0000	1	1			
Placard													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST098		7							
				48511		7							
D3941-40 		Purchased	No			140	Each	0.0000	1	1			
Rubber Cushion													
CUT (1x) 40.00" PER DWG													

B52200 (1x)
B63061 (3x)

EP 9/10/21
B62265 (2x)
EP 9/10/21
B62266 (4x)
EP 9/10/21
EP 9/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 03, 2010 1:40:52 PM

Work Order ID: 61795

Parent Item: D3936-041

Parent Item Name: Mapbox Assembly

Start Date: 9/3/2010

Required Date: 9/14/2010

Start Qty: 1.00

Required Qty: 1.00

D3941-12 Purchased No



Rubber Cushion

CUT (1X) 12.00" PER DWG

MS20426AD3-4



RIVET

Purchased No

140 Each 0.0000 1 1

B63062 (3) B52201 (1K)



EP 5/10/10/21

100 Each 6,540.000 56 56



EP 5/10/10/21

Location

Loc Qty

Loc Code

ST316

6540

104374

2540

110398

4000

256

MS20426AD3-4



Rivet

Purchased No

100 Each 14,844.00 8 8



EP 5/10/10/21

Location

Loc Qty

Loc Code

ST316

14844

4179

3006

4444

5678

4533

6160

5 too long
10.10.13
051 042

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

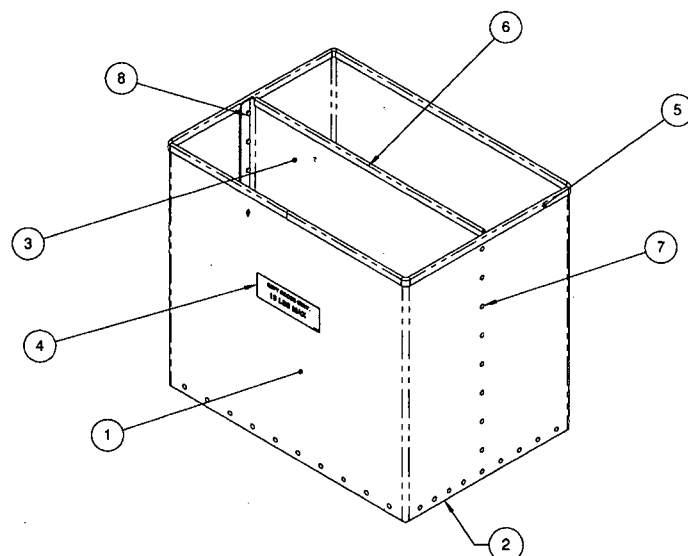
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	1	D3936-1	SIDES
2	1	D3936-3	BOTTOM
3	1	D3936-5	DIVIDER
4	1	D3938-3	PLACARD
5	1	D3941-40	RUBBER CUSHION
6	1	D3941-12	RUBBER CUSHION
7	56	MS20426AD3-4	RIVET
8	8	MS20426AD3-5	RIVET



D3936-041 MAPBOX ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3936-041" AND B/N USING A WHITE FINE POINT PAINT MARKER
- 7) WEIGHT: 2.54 lbs

ASSEMBLY INSTRUCTIONS

1. BEND D3936-1/3/5 PARTS PER SHEETS 2-7.
2. POSITION D3936-5 DIVIDER IN PLACE INSIDE THE D3936-1 SIDES AND CLECO IN PLACE.
3. POSITION THE D3936-3 BOTTOM IN PLACE AGAINST THE D3936-5 DIVIDER AND INSIDE THE D3936-1 SIDES.
4. TRANSFER DRILL 10X $\phi 0.098$ (#40 DRILL) HOLES FROM THE D3936-3 BOTTOM TO THE D3936-5 DIVIDER. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
5. TRANSFER DRILL 38X $\phi 0.098$ HOLES FROM D3936-1 SIDES TO D3936-3 BOTTOM. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
6. REMOVE ALL CLECOS AND COUNTERSINK 64X EXTERIOR HOLES $\phi 0.179 \times 100^\circ$. DEBURR ALL HOLES IN ALL PARTS.
7. REASSEMBLE PARTS USING CLECOS IN EVERY THIRD HOLE TO MAINTAIN ALIGNMENT.
8. RIVET D3936-1 SIDE TO D3936-5 DIVIDER USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
9. RIVET D3936-5 DIVIDER TO D3936-3 BOTTOM USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
10. RIVET D3936-3 BOTTOM TO D3936-1 SIDE USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
11. POWDER COAT ASSEMBLY PER NOTE 2.
12. TEST FIT RUBBER CUSHION TO TOP EDGE OF MAPBOX. TRIM AS REQUIRED FOR PROPER FIT.
13. REMOVE RUBBER CUSHION.
14. APPLY SMALL BEAD OF SILICONE/ADHESIVE TO TOP EDGE OF MAPBOX.
15. SLIDE RUBBER CUSHION OVER EDGE AND PRESS INTO SILICONE/ADHESIVE.
16. WIPE OFF ANY EXCESS SILICONE/ADHESIVE BEFORE IT DRIES/CURES.
17. APPLY D3938-3 PLACARD AS SHOWN.
18. ALLOW SEALANT/ADHESIVE TO CURE/DRY 24 HRS BEFORE SHIPPING PART.

RELEASED
2009-08-28
MND

SHOP COPIED
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 41795

REV.	NEW ISSUE	BY	DATE
DESIGN	DESIGN	DATE	09.07.08
DRAWN	DRAWN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	CHECKED	DRAWING NO.	REV. A
MFG. APPR.	MFG. APPR.	D3936	SHEET 1 OF 7
APPROVED	APPROVED	TITLE	SCALE
DE APPR.	DE APPR.	MAPBOX	NTS
DATE	09.07.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

10-9-03

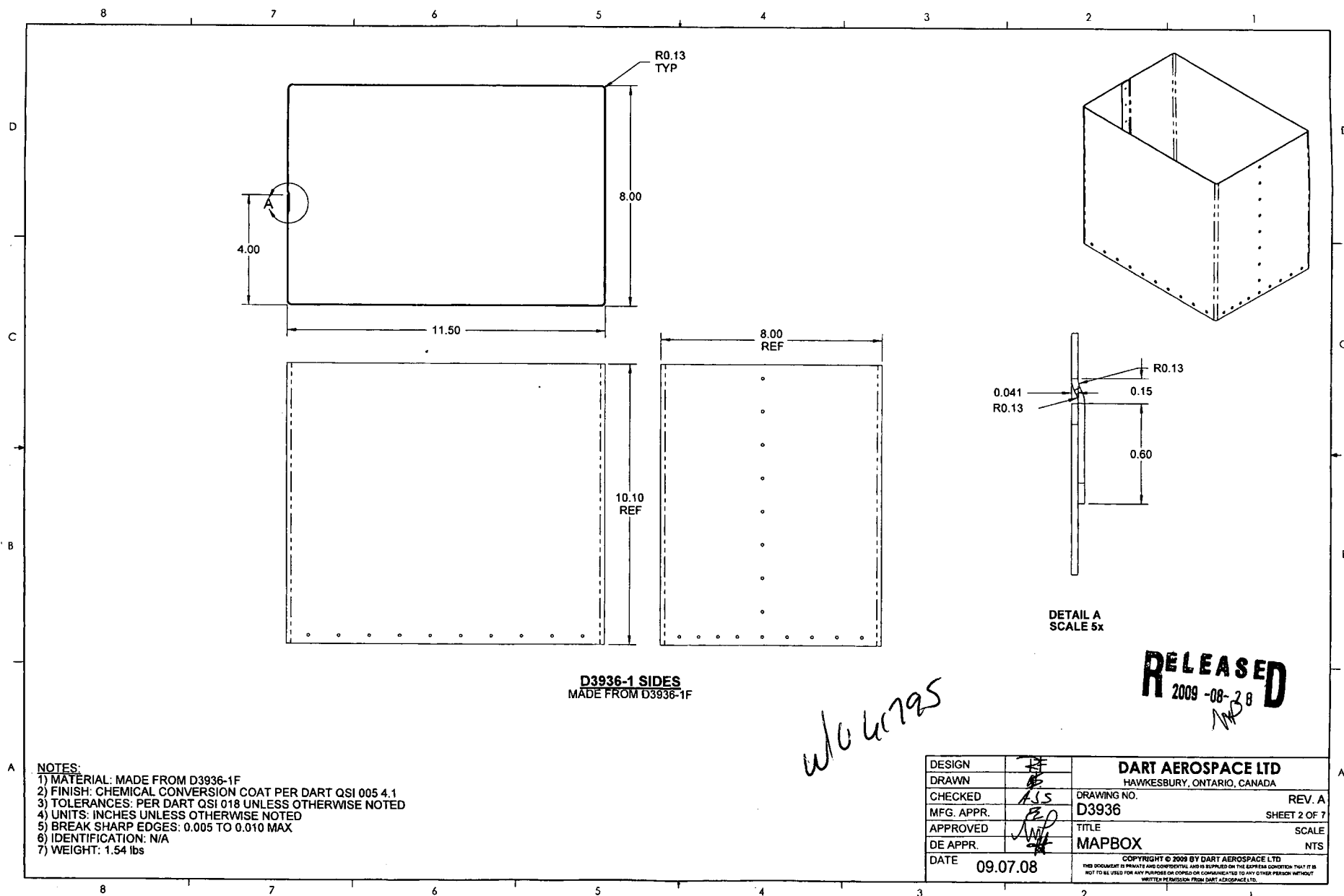
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



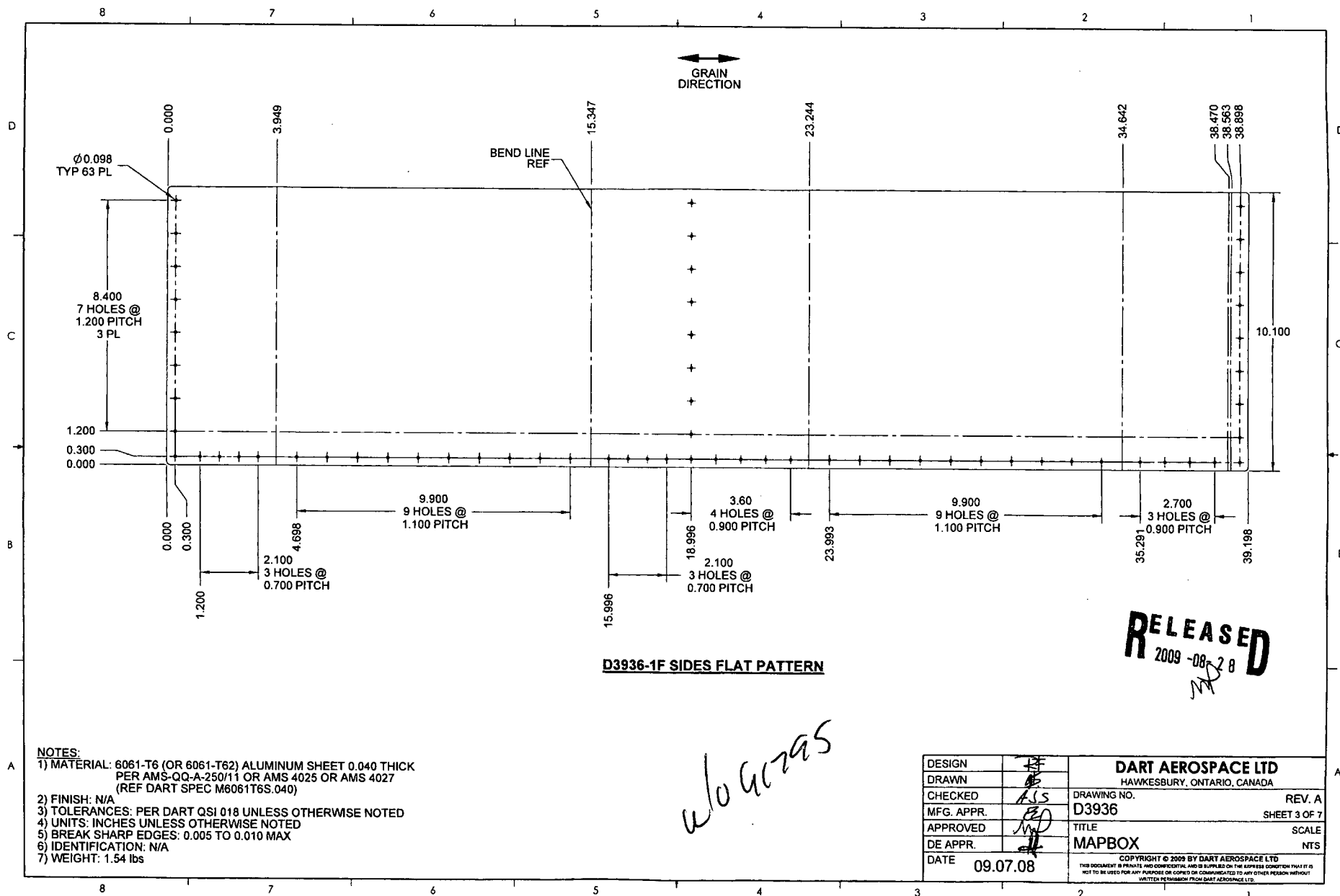
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
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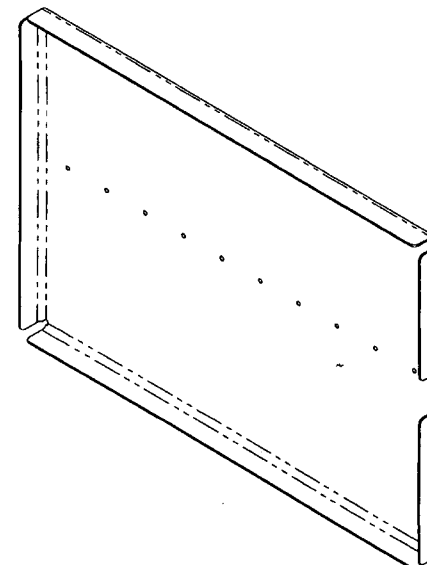
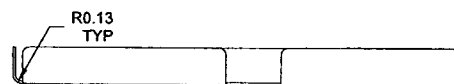
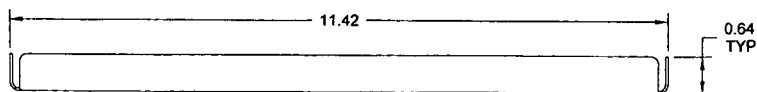
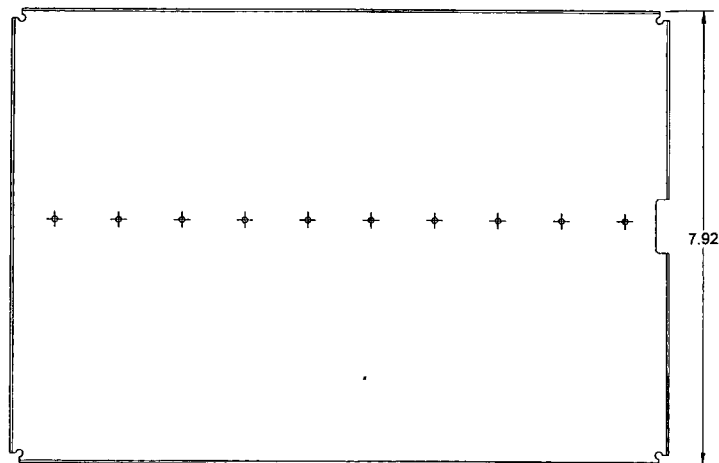
8 7 6 5 4 3 2 1

D

C

B

A



D

C

B

A

D3936-3 BOTTOM
MADE FROM D3936-3F

w/04796

RELEASED
2008-08-28

NOTES:

- 1) MATERIAL: MADE FROM D3936-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.43 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ALS</i>	DRAWING NO.	REV. A
MFG. APPR.		D3936	SHEET 4 OF 7
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8 7 6 5 4 3 2 1

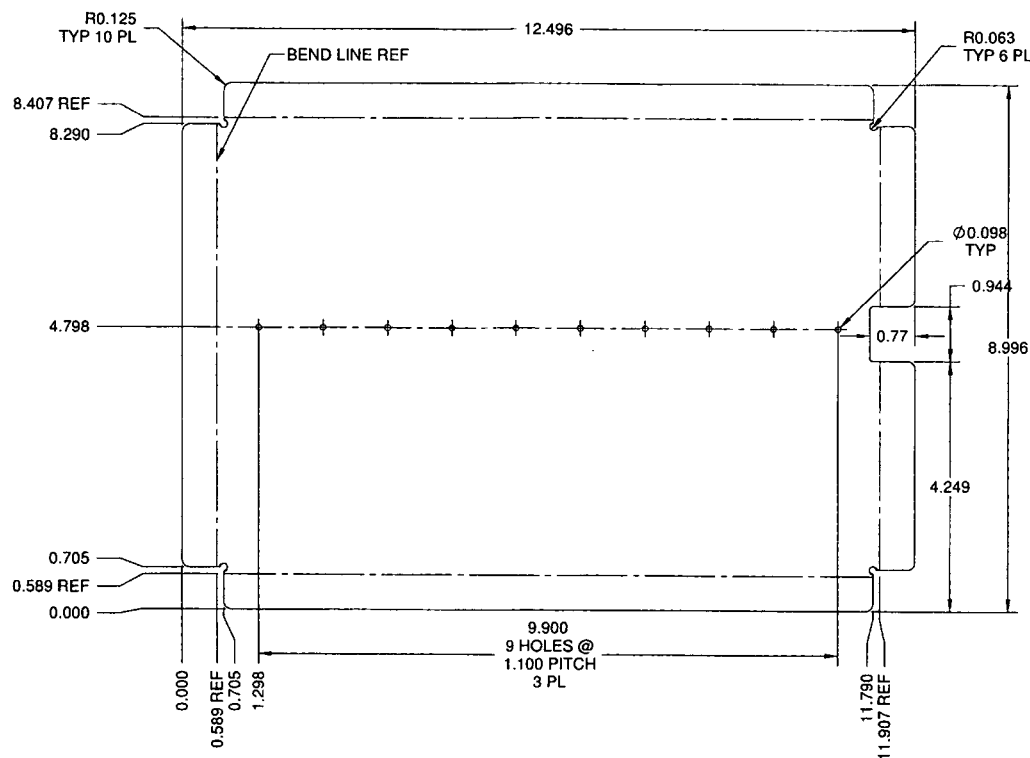
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3936-3F BOTTOM FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.040)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.43 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3936	SHEET 5 OF 7
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

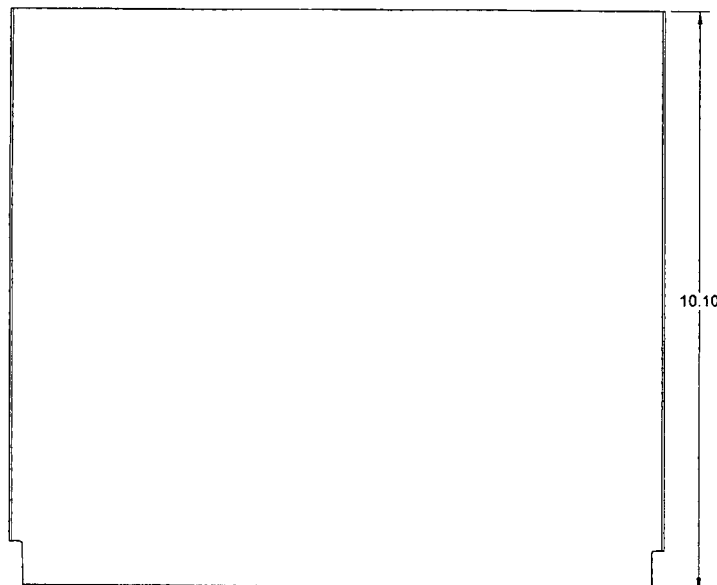
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D

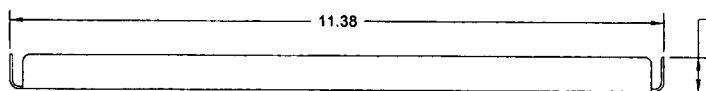
C

B

A

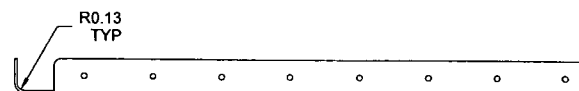


10.10



11.38

0.60
TYP



R0.13
TYP

D3936-5 DIVIDER
MADE FROM D3936-5F

wlv 61795

RELEASED
2009-08-28

NOTES:

- 1) MATERIAL: MADE FROM D3936-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.50 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ALS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3936	SHEET 6 OF 7
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	MAPBOX	NTS
DATE	09.07.08	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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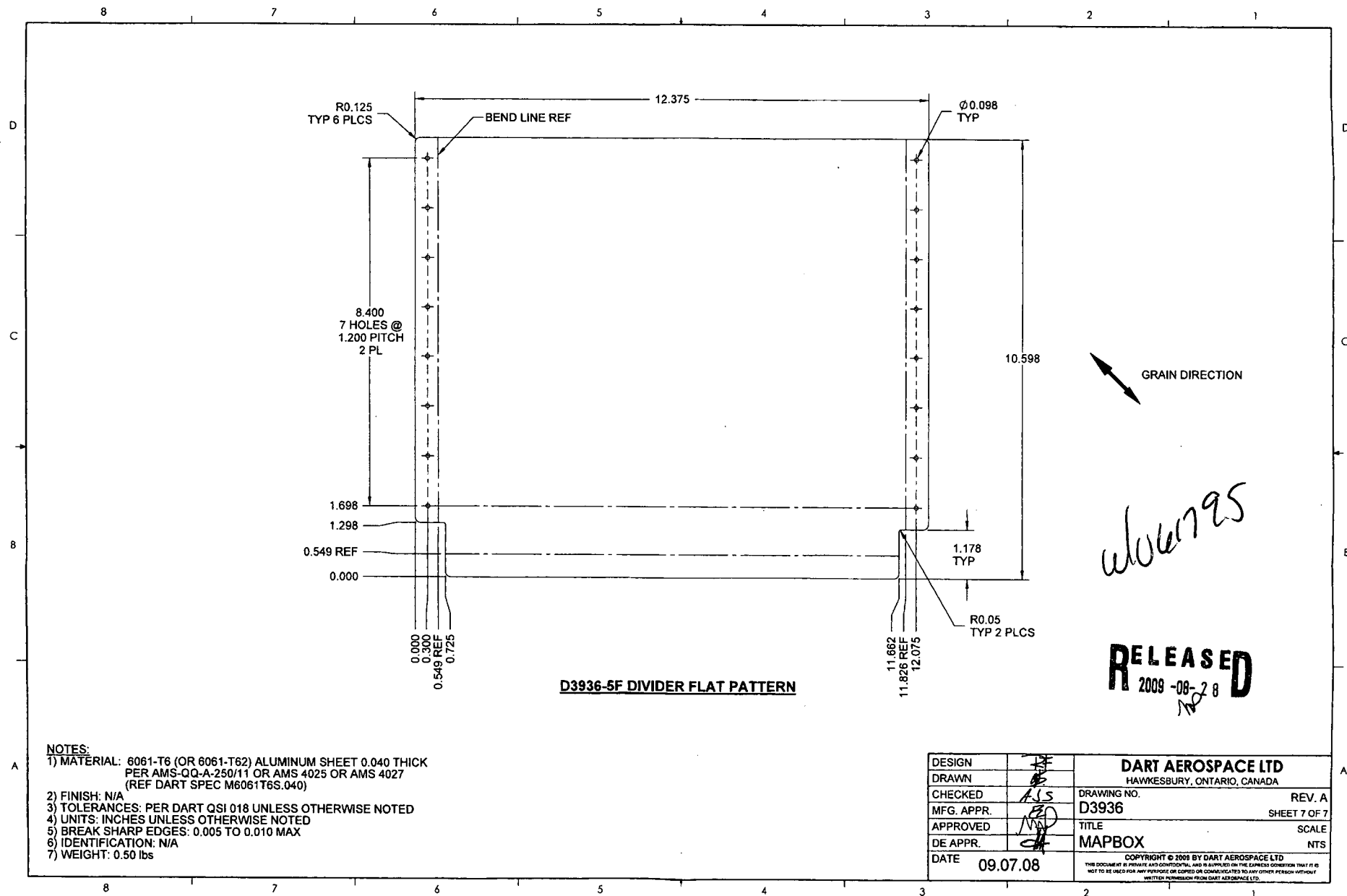
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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